

Work Order ID 100532 -2

April-22-13 1:44:00 PM

split

100532

Page 1

Item ID: D2574

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Alt In 205

Stop *NS2*

Start Date: 4/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 13-04-25 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2574

F

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 100 532

Double check by: SL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

6 4 2
OK 13/06/22
OK 2013-06-20

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

6 4
OK 13/06/22
OK 2013-06-20

Work Order ID 100532

April-22-13 1:44:00 PM

100532

Page 2

Item ID: D2574

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft In 205

Start Date: 4/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

OK 13/06/22

6 8 OFC 2015-06-20

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

13-6-24

6 8

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

6

DAS 05 13.06.24

Work Order ID 100532

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100532

Page 3

Item ID: D2574

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Aft In 205

Start Date: 4/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
3200F
11:30

6x8 m/f 13/06/27

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6x d all 13/06/27

170

Identify as per dwg & Stock Location: ST442

0.00

170

Packaging

Memo

0.00

Packaging

6x M.D. 13-06-28

m125620

Work Order ID 100532

April-22-13 1:44:00 PM

100532

Page 4

Item ID: D2574

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Aft In 205

Stop ***NS2***

Start Date: 4/25/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/03/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/7/2 JF
MS 13-04-20

Picklist Print

April-22-13 1:44:00 PM

Page 1

Work Order ID: 100532

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 4/25/13

Required Date: 5/03/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 Saddle Billet		Manufactured	No			110	Each	17.0000	1	12	12	13-06-01	

Location	Loc Qty	Loc Code
MAT041	2	
76838	2	
MAT044	13	
79874	7	
97922	6	
MAT045	2	
88960	2	

99218

12

⑦ JFC 2013-06-20

DART AEROSPACE LTD	Work Order: 100532
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#1	#2	#3	#4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.010	8.001	8.001	8.001		
F	0.490	0.510		0.5045	.501	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		0.5005	0.500	0.499	.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.5685	0.569	0.568	.567		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	0.1265	0.127	.127		
Q	0.115	0.135		.131	0.133	0.133	.135		
R	0.240	0.260		.250	0.253	0.253	.252		
S	0.115	0.135		0.130	0.131	0.131	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.241	.240		
W	0.115	0.135		0.133	.132	.131	.132		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.624	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.247		
AE	1.500	1.520		1.511	1.511	1.513	1.511		
AF	0.115	0.135		0.133	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		0.250	.250	.248	.249		
AI	2.000	2.020		2.003	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				0.033	0.033	0.033	0.033		

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 13-06-03	Date: 18-6-28

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 100532
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

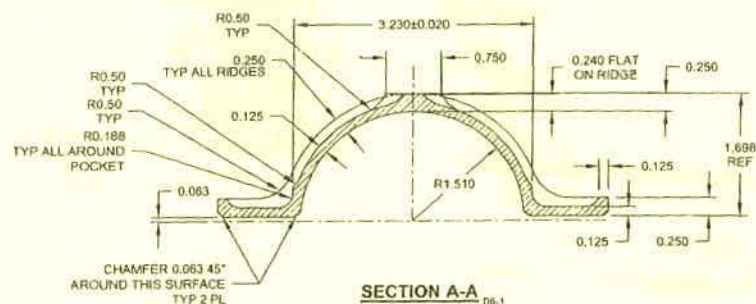
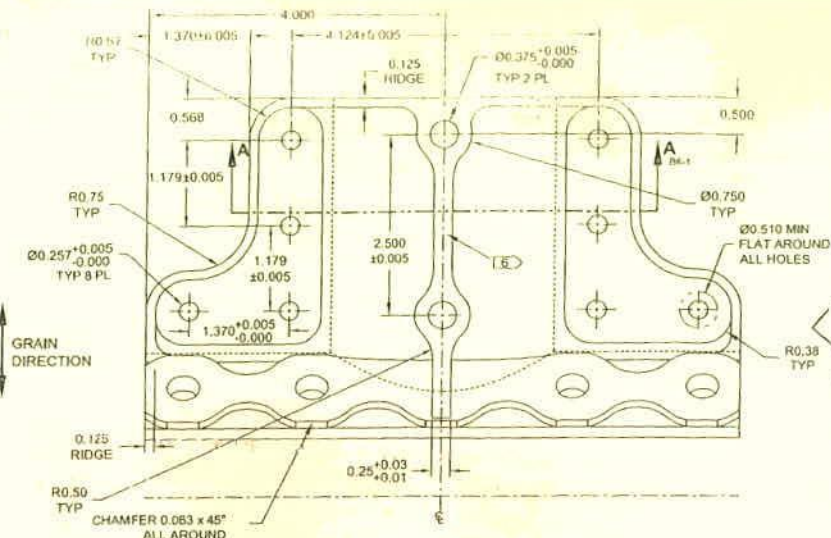
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	3	4	By	Date
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.001				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.500	.499				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.567				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.122				
P	0.115	0.135		.127	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.251				
S	0.115	0.135		.131	.131				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.133	.133				
X	0.307	0.312		.309	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.358	.361				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.249				
AE	1.500	1.520		1.512	1.511				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.275	.275				
AH	0.240	0.260		.249	.248				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	SK
Date:	13/06/22

Audited by:	SK
Date:	13-6-24

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



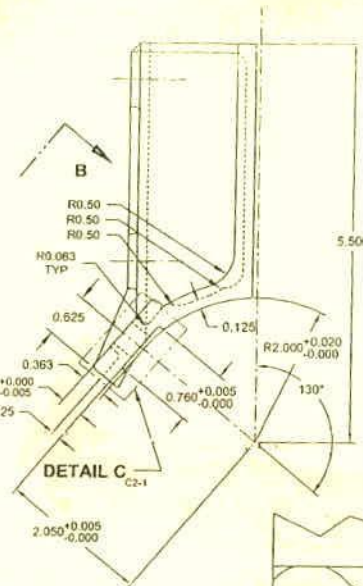
SECTION A-A
D6-1

D2574 INNER AFT SADDLE

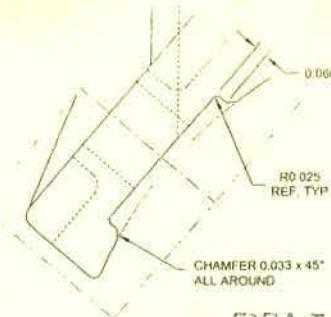


NOTES:

- 1) MATERIAL: 7075-T7351 PER QQ-A-250/12 (REF DART SPEC. D6101-005)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2574" AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
- 7) WEIGHT: 0.80 lbs

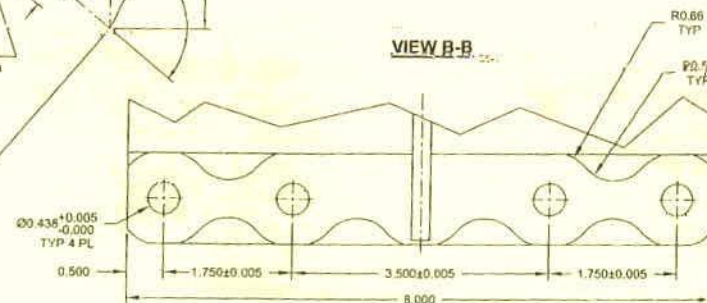


DETAIL C
C2-1



DETAIL C
SCALE: 2x
C4-1

VIEW B-B
C2-1



F	D6101-005 WAS D6102-003 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 4	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCOMP. DEC 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR., 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2574	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		INNER AFT SADDLE	NTS
DATE	12.11.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

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